

Date: Monday, 02/06/2008 4:32:31 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG AND BRACKET
Job Number	: 39641		
Estimate Number	: 11128		
P.O. Number	:	Part Number	: D301617
This Issue	: 02/06/2008 S.O. No. :	Drawing Number	: D3016 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 38251	Material	:
Written By	:	Due Date	: 10/06/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JP 08-6-2</u>		
Comment	: Est. B 03.05.09 Reformat KJ/RF Est Rev:C 08-04-11 now made on water jet DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M4130NS049	4130 Sheet .049 wall
-----	------------	----------------------



Comment: Qty.: 0.0182 sf(s)/Unit Total: 0.1817 sf(s)

4130 Sheet .049 wall

Material: AISI 4130N Sheet, 0.049" thick

(M4130N-S049)

Identify for D3016-17

Batch: 11612

IR 8-6-9

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3016

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

IR 8-6-9

08/06/09

20

20 Ham

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IR 8-6-9

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 08/06/09 (+20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/06/2008 4:32:31 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG AND BRACKET

Job Number: 39641

Part Number: D301617

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and bag with light oil (Vactra oil #2), then Stock

Location: _____

PAT Duval

JS 08/06/09 (R20)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08/26/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

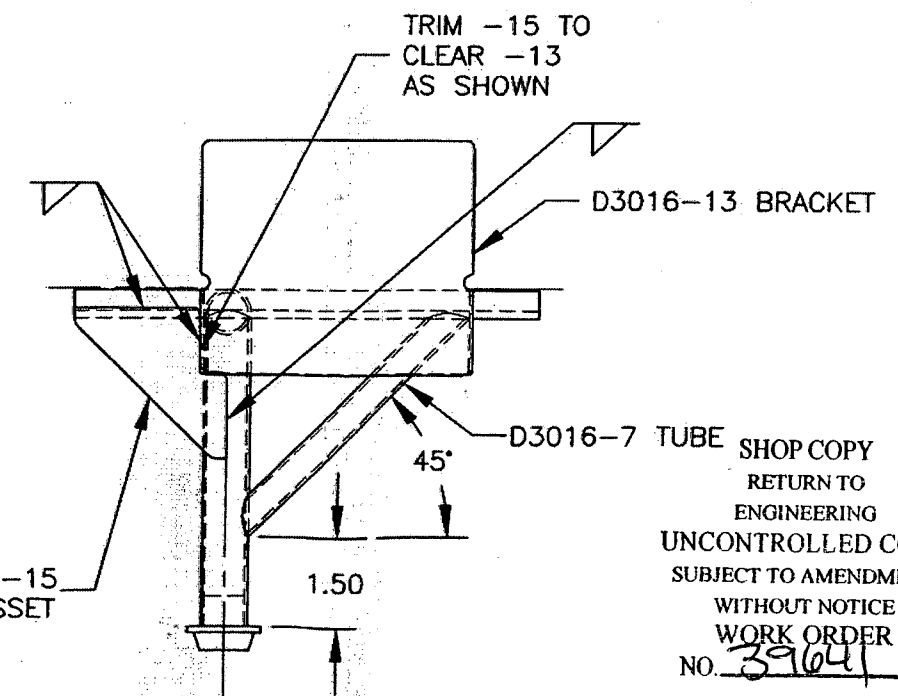
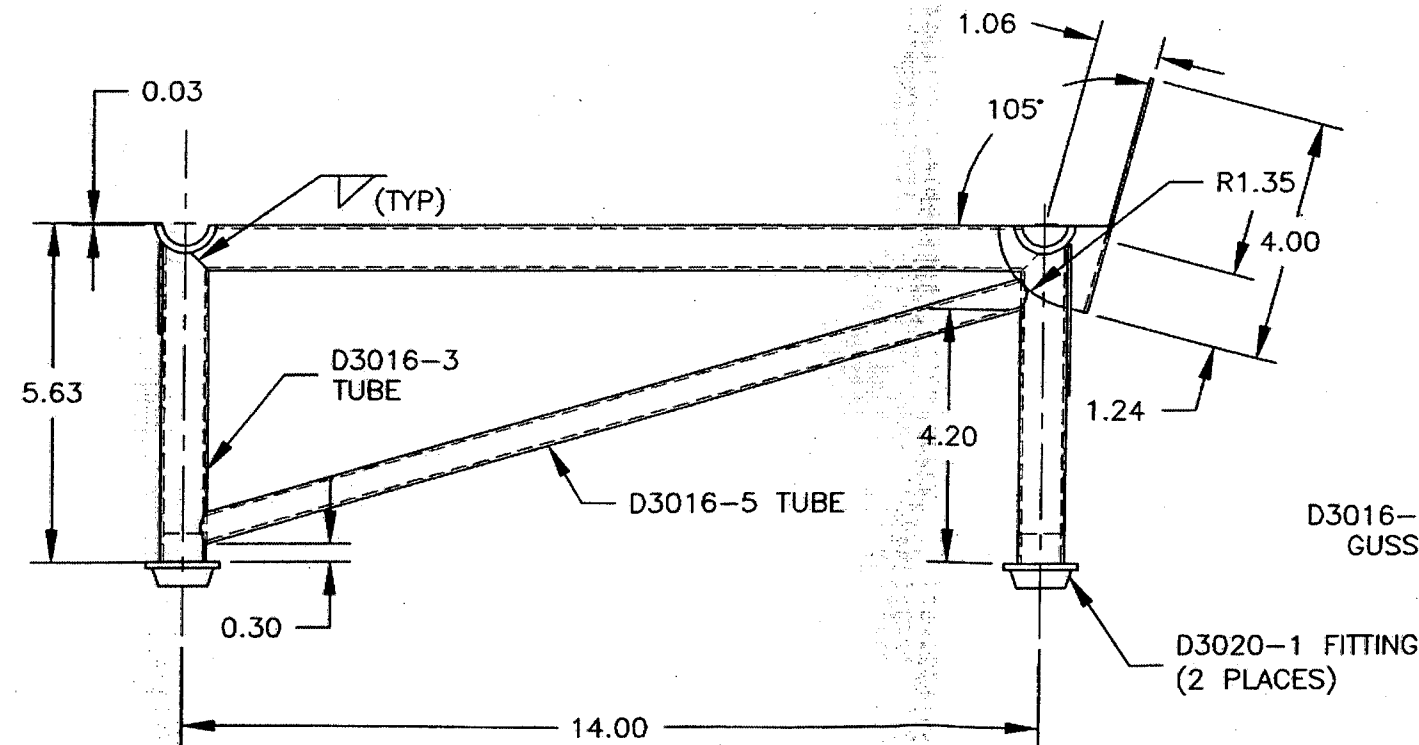
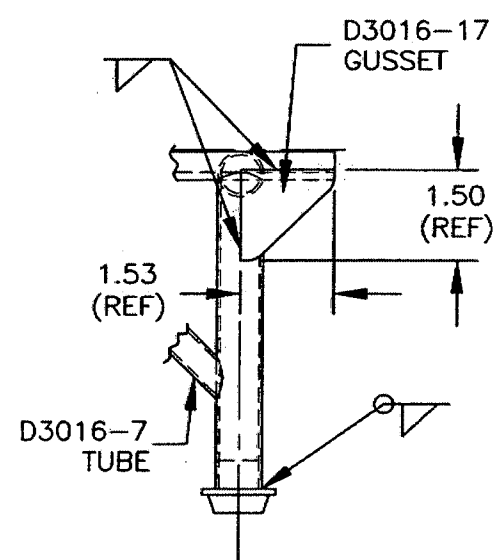
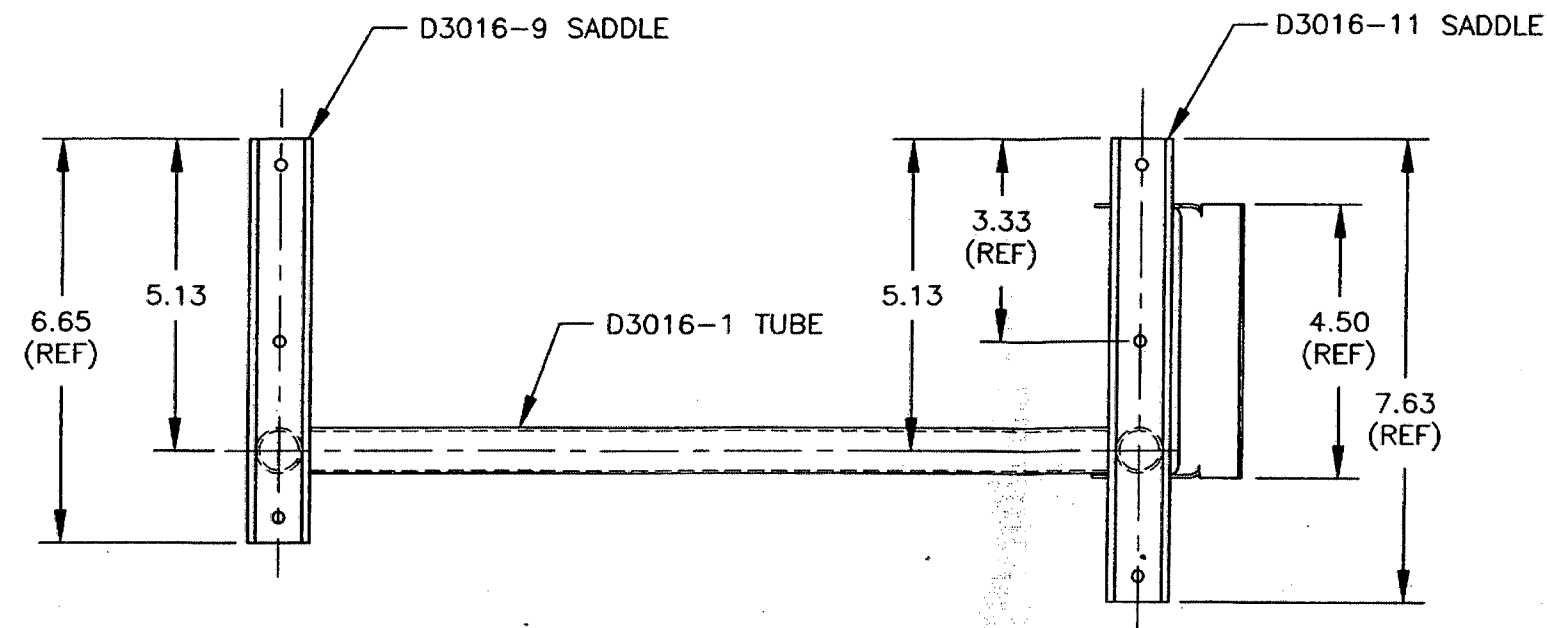
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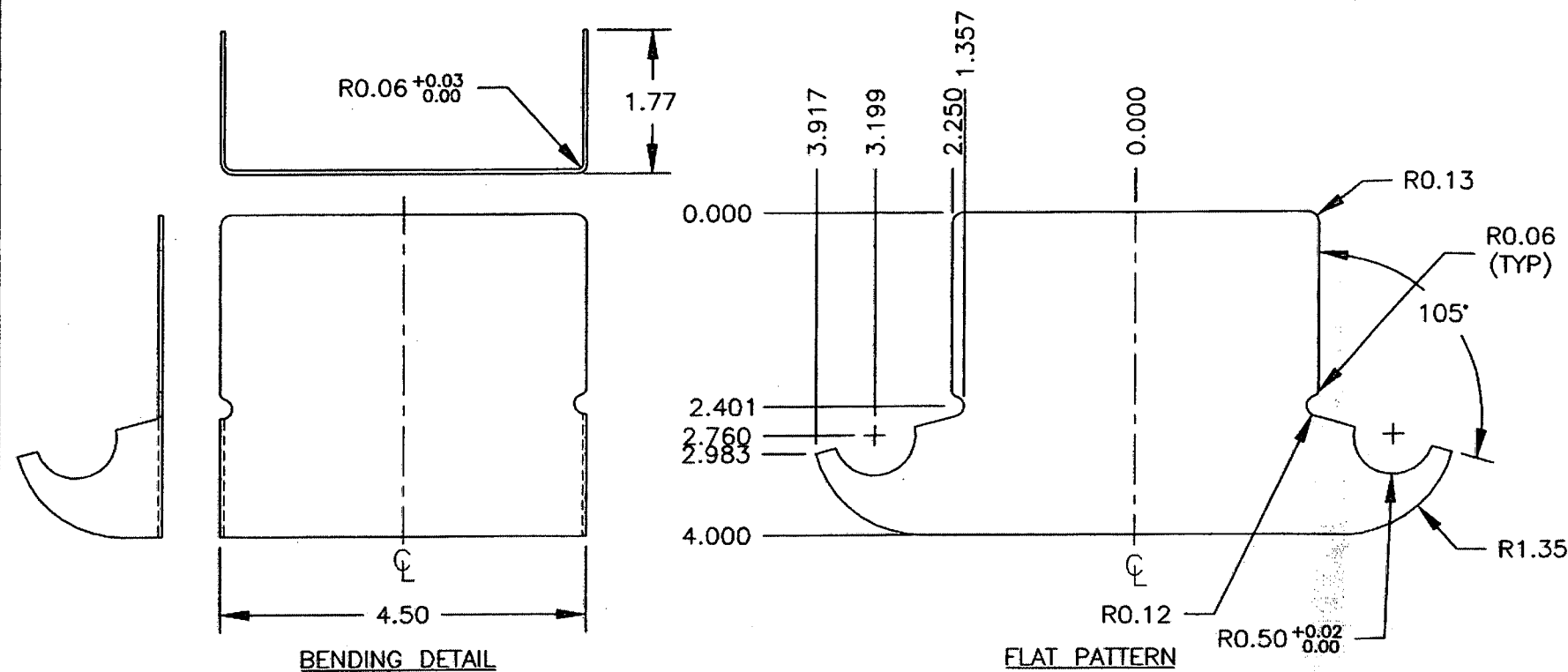
D3016-041 SEAT FRAME ASSEMBLY



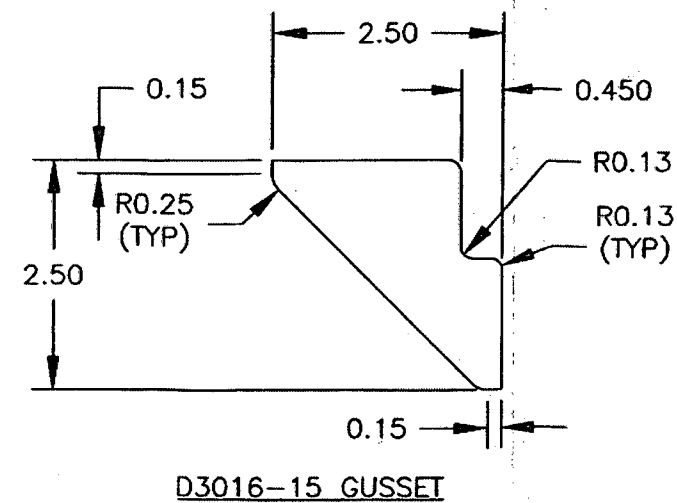
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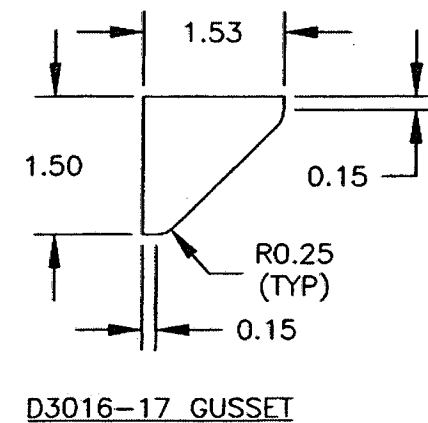
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	DATE		
	01.05.18		
	DRAWING NO.	TITLE	REV. A
	D3016	SEAT FRAME ASSEMBLY	SHEET 2 OF 3
		SCALE	1:3



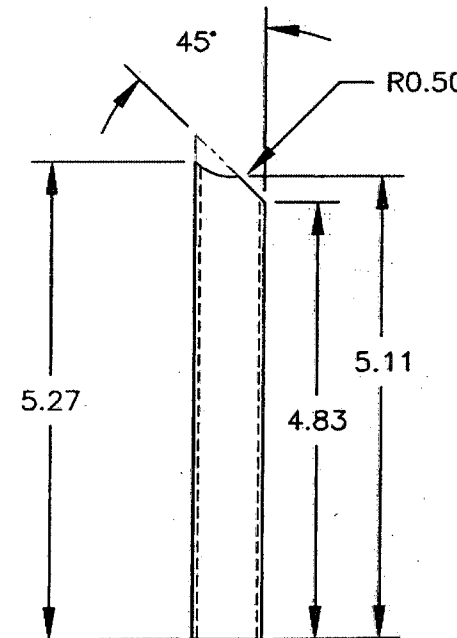
D3016-13 BRACKET



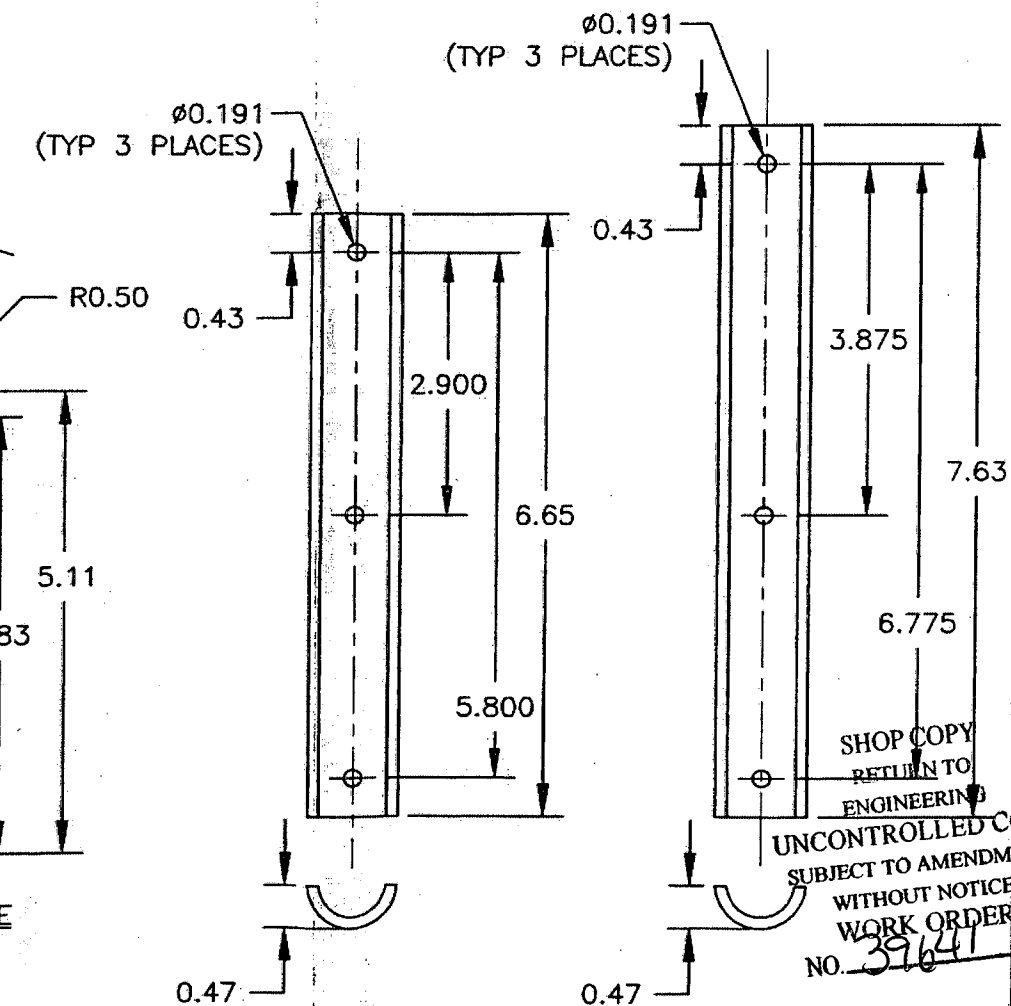
D3016-15 GUSSET



D3016-17 GUSSET



D3016-3 TUBE



D3016-9 SADDLE

D3016-11 SADDLE

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CHECKED #	APPROVED #	DRAWING NO. D3016	REV. A SHEET 3 OF 3
DATE 01.05.18	TITLE SEAT FRAME ASSEMBLY	SCALE 1:2	

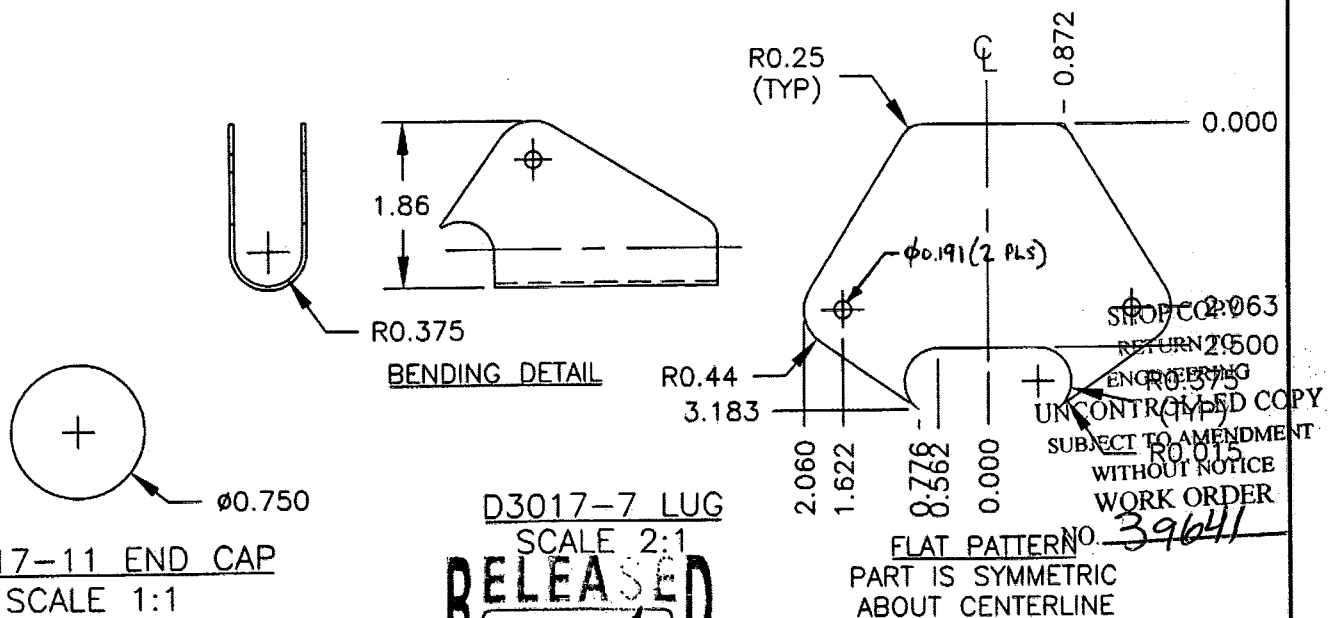
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

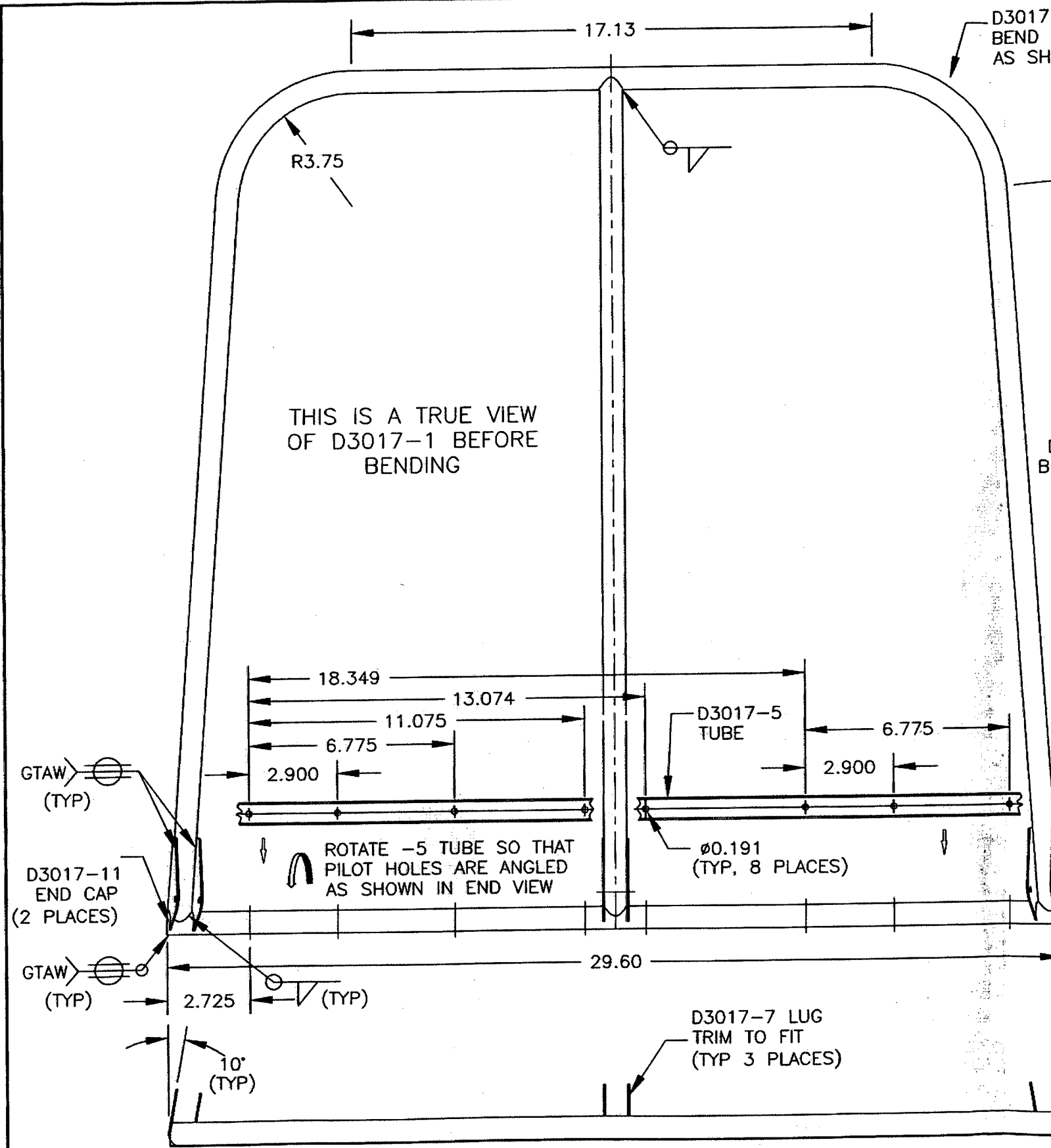
NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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D3017-1 TUBE,
BEND AND CUT
AS SHOWN

17.92
DIST BETWEEN
BEND TANGENTS

DRILL $\phi 0.128$ HOLES TO LINE UP
WITH D3023-1 BACK PANEL

ANGLE
TO HOLE
CENTERLINE

R4.00

22.05

27.89

14.9°

26.2°

R0.38
(TYP)

21.30

27.14

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D3017-3 TUBE

RELEASED
01-06-07

D3017-041 BACK FRAME ASSEMBLY
(D3017-1 TUBE, D3017-5 TUBE)

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CP

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CP

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

CHECKED

CP

APPROVED

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DRAWING NO.

D3017

REV. A

SHEET 2 OF 2

DATE

01.05.18

TITLE

BACK FRAME ASSEMBLY

SCALE

1:4

DART AEROSPACE LTD	Work Order:	39641
Description: LUG AND BRACKET GUSSET	Part Number:	D3016-17
Inspection Dwg: D3016-17 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/> First Article	<input type="checkbox"/> Prototype
<p>1. Introduction</p> <p>2. Materials and Methods</p> <p>3. Results</p> <p>4. Discussion</p> <p>5. Conclusion</p>	<p>1. Introduction</p> <p>2. Materials and Methods</p> <p>3. Results</p> <p>4. Discussion</p> <p>5. Conclusion</p>

[illegible]

Measured by: RB	Audited by: S	Prototype Approval: S
Date: 8-6-9	Date: 08/06/09	Date: 1/7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	